

HAWKEYE

INTERNATIONAL, LTD.

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DATA SHEET

FLASH TAPE 1

FLASH TAPE 1 is a general-purpose high temperature, fully cured silicone adhesive tape. Designed for use primarily in plastic and bonding shops for "flash" control, masking, holding, or positioning. It is equally useful for chemical milling operations, riveting and in paint departments. Flash Tape 1 is excellent on panels or parts being subjected to etching by either acid or other caustic solution.

SPECIFICATIONS

Thickness:	.002" Total Tape Thickness
Width:	1" and 2" Standard
Length:	72 yards per roll - Standard
Adhesion:	20 oz. per inch width
Elongation:	100 %
Temperature Range:	-60 - 400 degrees F (-51 - 204 degrees C)
Color:	Blue

NOTE: Technical information furnished by HAWKEYE is based on laboratory findings and is believed to be correct. No warranties of any kind are made except that materials supplied are HAWKEYE standard quality. All risk and liability arising from handling, storage and use of HAWKEYE products, as well as compliance with applicable legal restrictions rests with the buyer.

DATA SHEET

FLASH TAPE 2

FLASH TAPE 2 is an all-purpose, high temperature, fully cured silicone adhesive tape. It is designed for use when Flash Tape 1 does not provide enough flash resistance for an individual application.

FLASH TAPE 2 is intended for use primarily in plastic and bonding shops for "flash" control, masking, or position. It is equally useful elsewhere, for chemical milling operations, riveting and in paint departments. This tape is excellent on panels or parts being subjected too etching by either acid or other caustic solutions.

SPECIFICATIONS

Thickness:	.003" Total Tape Thickness
Width:	1" and 2" widths - Standard
Length:	72 yards per roll - Standard
Adhesion:	20 oz. per inch width
Elongation:	100 %
Temperature Range:	-60 - 400 degrees F (-51 - 204 degrees C)
Color:	Blue

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DATA SHEET

FLASH TAPE 1R

FLASH TAPE 1R is a general purpose, high tensile polyester film with a rubber adhesive. It is designed for use primarily in plastic and metal bonding shops, where silicone adhesive has been deemed inadvisable. Recommended uses include "flash" control, masking, holding and positioning.

SPECIFICATIONS

Thickness:	002" Total Tape Thickness
Width:	1" and 2" - Standard
Length:	72 yards per roll - Standard
Adhesion:	40 oz. per inch width
Elongation:	60%
Temperature Range:	-60 - 350 degrees F (-51 - 176 degrees C)

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DATA SHEET

FLASH TAPE 2R

FLASH TAPE 2R is a general-purpose polyester tape, with high-tensile strength. It is intended for use when a rubber adhesive is required and Flash Tape 1R does not provide adequate strength for a particular application.

FLASH TAPE 2R has been designed for use in plastic and metal bonding shops for “flash” control, positioning, masking, riveting and paint departments.

SPECIFICATIONS

Thickness:	.003” Total Tape Thickness
Width:	1” and 2” - Standard
Length:	72 yards per roll - Standard
Adhesion:	40 oz per inch width
Elongation:	80%
Temperature:	-60 - 350 degrees F (-51 - 176 degrees C)

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DATA SHEET

FLASH TAPE 1A

FLASH TAPE 1A is a general purpose, high tensile polyester film with an acrylic adhesive. It is designed for use primarily in plastic and metal bonding shops, where silicone adhesive has been deemed inadvisable. Recommended uses include "flash" control, masking, holding and positioning.

SPECIFICATIONS

Thickness:	.002" Total Tape Thickness
Width:	1" and 2" - Standard
Length:	72 yards per roll - Standard
Adhesion:	40 oz. per inch width
Elongation:	60%
Temperature Range:	-60 - 350 degrees F (-51 - 176 degrees C)

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DATA SHEET

FLASH TAPE 5

Flash Tape 5 is an all-purpose, high temperature, fully cured silicone adhesive tape. It is designed for use when Flash Tape 1 and 2 does not provide enough flash resistance for an individual application. Flash Tape 5 is a 5 mil high tensile polyester film coated with 1 1/2 mils of fully cured silicone adhesive.

Flash Tape 5 is applied to the tool or part so the excess adhesive will flow over it. At the completion of the cure cycle, the tape is pulled away which breaks the cured adhesive. This process leaves a clean bondline.

Flash Tape 5 can also be used for potting inserts. After the Flash Tape 5 has been placed on the part, drill through the tape and fill with insert and potting compound. After the cure, the Flash Tape 5 will pull away clean.

SPECIFICATIONS

Film Thickness (inches):	.005"
Adhesive Thickness (inches):	.0015"
Width:	1" and 2"
Roll Size:	36 yds per roll
Adhesion oz/inch/width:	20 to 25
Temperature Range	-40°F to 400°F (-51°C - 204°C)
Color:	Red or Blue
Shelf Life:	1 year when stored at 72°F (22°C)

* Other widths and lengths available

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DATA SHEET

FLASH TAPE 1RD

FLASH TAPE 1RD is an all-purpose double-backed tape, designed too hold items in place in vacuum bag layups. It adheres well to our various release products, and is ideal for holding honeycomb in place while machining. The tape is relatively inexpensive, and is economical when used in low temperature applications, although it will withstand temperatures of 350 degrees F (176 degrees C) for normal usage.

Flash Tape 1RD is a 1 mil polyester film coated on both sides with a non-silicone adhesive and is offered in both 1 and 2 inch widths as standard size.

SPECIFICATIONS

Thickness:	.0035" Total Thickness
Width:	1" and 2" - Standard
Length:	72 yards per roll - Standard
Color:	Yellow
Elongation:	60%
Temperature:	-40 - 350 degrees F (-40 - 176 degrees C)

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DATA SHEET

HK 1CBS PRESSURE SENSITIVE TAPE

HK 1CBS PRESSURE SENSITIVE TAPE is an all-purpose double-backed tape, designed too hold items in place in vacuum bag layups. It adheres well to our various release products, and is ideal for holding honeycomb in place while machining. The tape is relatively inexpensive, and is economical when used in low temperature applications, although it will withstand temperatures of 350 degrees F (176 degrees C) for normal usage.

HK 1 CBS PRESSURE SENSITIVE TAPE is a 1 mil polyester film coated on both sides with a non-silicone adhesive and is offered in both 1 and 2 inch widths as standard size.

SPECIFICATIONS

Thickness:	.0025" Total Thickness
Width:	1" and 2" - Standard
Length:	72 yards per roll - Standard
Color:	Clear
Elongation:	100%
Temperature:	-40 - 350 degrees F (-40 - 176 degrees C)

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DATA SHEET

HK1150 HONEYCOMB HOLD DOWN TAPE

HK1150 HONEYCOMB HOLD DOWN TAPE is a ten mil double-backed tape used primarily in honeycomb laydown. The thick adhesive is designed for core impediment. The adhesive is a non-silicone to prevent core contamination. For complete release of honeycomb from the HK1150, the cells should be sprayed with MEK or acetone.

SPECIFICATIONS

Thickness:	.010" Total Tape Thickness
Width:	1" and 2" - Standard
Length:	25 and 36 yards per roll - Standard
Adhesive Base:	Non-Silicone
Elongation:	15%
Adhesive:	90 oz./inch width
Temperature:	200 degrees F (93 degrees C) Maximum Recommended

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HK10CBS TAPE HONEYCOMB HOLD DOWN TAPE

HK10CBS HONEYCOMB HOLD DOWN TAPE is a ten mil double-backed tape used primarily in honeycomb laydown. The thick adhesive is designed for core impediment. The adhesive is a non-silicone too prevent core contamination. For complete release of honeycomb from the HK10CBS, the cells should be sprayed with MEK or acetone.

SPECIFICATIONS

Thickness:	.010" Total Tape Thickness
Width:	1" and 2" - Standard
Length:	25 and 36 yards per roll - Standard
Adhesive Base:	Non-Silicone
Elongation:	15%
Adhesive:	90 oz./inch width
Temperature:	200 degrees F (93 degrees C) Maximum Recommended

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DATA SHEET

HK1151 PRESSURE SENSITIVE TAPE

HK1151 PRESSURE SENSITIVE TAPE is a 2 mil., high temperature nylon tape, coated with a pressure sensitive rubber-base adhesive. Contamination problems common with silicone adhesive are eliminated with HK1151.

This tape is designed to provide clean removal during masking operation in applications involving high temperature and pressure. The tape is thin, but exceptionally tough. Elongation properties provide a high degree of conformability. The tape has very low shrinkage in high temperature applications is essentially pin-hole free.

- METAL BOND MASKING - Non-silicone adhesive allows use on parts where subsequent painting or bonding is necessary. Removes clean after 350 degrees F (176 degrees C) autoclave exposure.
- HIGH TEMPERATURE BAKE CYCLES - Clean removal from metal has been experienced after 24 hours at 350 degrees F (176 degrees C). In shorter cycles, the tape can be expected to provide satisfactory performance in 400 degree F (204 degree C) bake cycles. The high stretch and thinness offer excellent conformability and clean sharp edges.

SPECIFICATIONS

Thickness:	.0035" total tape thickness
Width:	1" and 2" - Standard
Length:	72 Yards - Standard
Color:	White
Elongation:	500%
Adhesion to Steel:	32 oz/inch width
Temperature:	100 - 400 degrees F (37 - 204 degrees C)

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DATA SHEET

FLASH RELEASE 2

FLASH RELEASE 2 is a high temperature fluorocarbon 2 mil pressure sensitive tape with a fully cured silicone adhesive. Fully cured silicone adhesives do not transfer to parts. This tape is transparent and is therefore useful for “see-through” applications. Flash release 2 is offered in standard roll widths of 1 and 2 inches.

FLASH RELEASE 2 is designed for high temperature work where tough release problems exist, or in oven and autoclave operations. It will release from all resin systems without leaving a residue, and is ideal for masking in chemical milling and chemical processing.

SPECIFICATIONS

Backing Material	.002” FEP Film
Adhesive	fully cured silicone
Adhesive Thickness:	.0015”
Thickness:	.0035” Total Thickness
Width:	1” and 2” - Standard
Length:	36 Yards - Standard
Color:	Transparent
Elongation:	275%
Adhesion to Steel	20 oz./inch width
Tensile Strength	8 lbs/in
Dielectric Strength	9000 volts
Temperature:	-100 - 500 degrees F (-73 - 260 degrees C)

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DATA SHEET

HK1A TAPE/HK1S Tape

HK1 PRESSURE SENSITIVE TAPE is a high performance polyimide film for protection of gold finger contacts from molten solder during the hot air leveling process. HK1 is thin, tough and does not leave a residue which allows for easy removal. It is designed for use with all H.A.L. machines and may also be used for other high temperature applications, including coils, capacitors, harness and transformers, and wave soldering applications. It is also used to hold down peel ply fabrics, breathers, vacuum bag plates, thermal couplers, etc., on high temperature curves in the oven or autoclave.

SPECIFICATIONS

Adhesive Type:	Silicone
Thickness:	.0025" Total Thickness
Backing Thickness (in)	.0010
Adhesive Thickness (in)	.0015
Width:	To 36" Wide
Roll Length:	36 Yards – Standard
Adhesion to Steel:	25
Tensile Strength:	30 lbs/in. width
Elongation:	60%
Dielectric Strength (volts):	6500
Insulation Class (°C)	180
Color:	Amber
Temperature:	-100°F to 500°F (260°C)
Adhesive	HK1A has an acrylic adhesive HK1S has a silicone adhesive

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DATA SHEET

HK1-2 TAPE

HK1 PRESSURE SENSITIVE TAPE is a high performance polyimide film for protection of gold finger contacts from molten solder during the hot air leveling process. HK1 is thin, tough and does not leave a residue which allows for easy removal. It is designed for use with all H.A.L. machines and may also be used for other high temperature applications, including coils, capacitors, harness and transformers, and wave soldering applications. It is also used to hold down peel ply fabrics, breathers, vacuum bag plates, thermal couplers, etc., on high temperature curves in the oven or autoclave.

SPECIFICATIONS

Thickness:	.0037" - Total Thickness
Backing Thickness:	.002" polyimide film
Adhesive Thickness:	.0017"
Adhesive	cured Silicone
Width:	To 36" Wide
Roll Length:	36 Yards – Standard
Adhesive System	Silicone
Adhesion to Steel (oz/in)	25 oz per inch
Tensile Strength:	65 lb/in. width
Dielectric Strengthn (Volts)	12,000
Color:	Amber
Tensile Strength:	23 lbs/in. width
Elongation:	65%
Temperature:	To 700 Degrees F (371 degrees C)
Insulation Class	180°C
Flammability rating	Complies with UL-510 Test

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DATA SHEET

TOOL RELEASE

Tool Release is used to seal tools and masters while providing permanent releases on composite or metal tools. Tool Release is a PTFE film coated with high temperature pressure sensitive adhesive. Three adhesives are available. "S" is a silicone adhesive, "R" is a rubber adhesive and "A" is an acrylic adhesive. Since there is no fiberglass reinforcement in Tool Release, it will easily form to exact contours. The high dielectric and tensile strength makes this product an extremely durable insulation tape.

Tool Release is a multi-release product. It is customary to use this material for 50 cure cycles before replacement is necessary. Tool Release will seal masters and tool surfaces to prevent leakage and offers permanent release without transfer or contamination to the part.

SPECIFICATIONS

Tool Release	02	03	05	10
Film thickness	.002"	.003"	.005"	.010"
Adhesive thickness	.0015"	.0015"	.0015"	.0015"
Adhesion, oz/in-minimum(Steel)	30	35	40	45
Tensile Strength (lbs/in)	30	45	60	65
Dielectric Strength (volts)	9000	11000	15000	18000
Elongation%	150	175	275	200
Operating Temperatures	-100 – 500°F	-100 – 500°F	-100 – 500°F	-100 – 500°F

Maximum operating temperature: 550°F (285°C) for all thicknesses

When ordering please request the type of adhesive by designating "S", "R" or "A"

When ordering, please request thickness by designating "02", "03", "05" or "10"

Shelf Life: 1 year when stored at 72°F (22°C)

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DATA SHEET

HK63 PTFE TAPE

(Code No. 75037)

Substrate Type	Virgin, skived polytetrafluoroethylene	
Adhesive Type	Acrylic	
Overall Thickness	0.0050"	inches
(nominal)	0.127	(mm)
Substrate Thickness	0.0030"	inches
(nominal)	0.076	(mm)
Adhesive Thickness	0.0020"	inches
(nominal)	.051	(mm)
Breaking Strength	8.0	(pounds/inch of width)
(minimum)	70.1	(Newtons/5cm)
Operating Temperature	-40°F to 350°F -40°C to 177°C	
		(continuous)
Dielectric Strength	9,100	(total volts)
(minimum)		
Peel Strength	40.0	(ounces/inch of width)
(minimum)	21.9	(Newton/5cm)
Elongation%	100	(@break)
(Minimum)		
Volume Resistivity	>10	
Dye Penetration	Class 1	(Class 1,2,3, or 4)
Adhesive Shelf Life	>12/<24	(months)

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DATA SHEET

HK350 PTFE TAPE

HK350 Tape is often used as masking during metal bonding, roll covering on plastic extruders and for fine wire harnesses.

HK350 is subjected to a special process which lowers its elongation and increases its breaking strength for easier handling. The backing on the HK350 is a silicone pressure sensitive adhesive and the other side offers low coefficient of friction PTFE film which is thin and conformable.

HK350 meets the requirements of MIL-I-23594C, Type 1, Class 1

SPECIFICATIONS

Substrate Type	High Modulus Polytetrafluoroethylene
Adhesive Type	High temperature silicone
Overall Thickness (nominal)	.0040" (.102mm)
Substrate Thickness (nominal)	.0020" (.051mm)
Adhesive Thickness (nominal)	.0020" (.051mm)
Adhesion to Steel (oz/in)	.0020
Breaking Strength (minimum)	13.0 pounds/inch width 114. (Newtons/5cm)
Tensile Strength (lbs/in)	25
Operating Temperature	-100°F to 500°F (-73 – 260°C)
Dielectric Strength (minimum)	8,200 (total volts)
Peel Strength (minimum)	20.0 oz/inch width (10.9 Newtons/5cm)
Elongation (% at break)	150
Volume Resistivity	> 10
Dye Penetration	Class 1
Insulation Class (°C)	180

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DATA SHEET

HK244-2HK BONDABLE PTFE

HK244-2HK Tape is an electrical insulation tape used for many applications in the aerospace and autoclave industries. HK244-2HK Tape is manufactured with a silicone thermosetting adhesive on skived and tensilized PTFE film. HK244-2HK provides excellent bonding of resins and varnishes; for use on high temperature coils, capacitors and wire harnesses. HK244-2 Tape is also printable.

SPECIFICATIONS

TEST METHOD

Backing:		PTFE Film
Adhesive		Silicone Thermosetting
Backing Thickness		.002"
Total Thickness		.004"/0.102mm
Adhesion to Steel	ASTM-D 1000	30 oz/in (3.2n/10mm)
Maximum Operating Temp:		500°F
Tensile Strength	ASTM-D 3759	30
Dielectric Breakdown	ASTM-D 149	10000 Volts
Breaking Strength		20 lbs/in (35 n/10mm)
Elongation (% at break)	ASTM-D-3759	200
Electrolytic Corrosion Factor		1.0
Adhesion to Steel		30 oz/in (3.2n/10mm)
Printable		Yes
U.L. Approval	File no E179854	Approved – Flame Retardant Cold Resistant
Core I.D.		3"
Roll Length (standard)		36 yds
Width:		.25" – 20"

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DATA SHEET

HK644 Pressure Sensitive Tape

HK644 Pressure Sensitive Tape is an oriented polytetrafluoroethylene (PTFE) with a high temperature silicone adhesive. The tape has been subjected to a special process which lowers its elongation and increases its breaking strength for easier handling. The adhesive on the HK644 is a silicone adhesive.

HK644 Pressure Sensitive Tape is often used as masking during metal bonding, roll covering on plastic extruders and for fine wire harness.

HK644 meets the requirements of MIL-I-23594C, Type I, Class 1

SPECIFICATIONS

Substrate Type	High Modulus Polytetrafluoroethylene (PTFE)
Adhesive Type	High Temperature Silicone
Overall Thickness (nominal)	.0040" (.103mm)
Substrate Thickness (nominal)	.0020" (.051mm)
Adhesive Thickness (nominal)	.0020" (.051mm)
Adhesion to Steel (oz/in)	.0025"
Breaking Strength (minimum)	13.0 pounds//inch width 114 (Newtons/5cm)
Tensile Strength (lbs/in)	25
Operating Temperature	-100°F – 500°F (-73°C – 260°C)
Dielectric Strength (volts)	8,200
Peel Strength	20.0 oz/inch width (10.9 Newton/5cm)
Elongation (% at break)	150
Volume Resistivity	>10
Dye Penetration	Class 1
Insulation Class (°C)	180
Color:	White

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DATA SHEET

TOOLCOAT PRESSURE SENSITIVE TAPES

#805

#807

#812

#816

TOOLCOAT PRESSURE SENSITIVE TAPE is a TFE impregnated fiberglass, manufactured from premium backing materials combined with high-quality, fully cured silicone adhesives, to offer optimum qualities of release, low friction, electrical insulation, dimensional stability and temperature resistance.

The primary design of TOOLCOAT TAPE is to stick to tool surfaces, to provide multiple releases and to cushion on all types of tooling surfaces.

Other applications are flash control, heat sealing machines, covering of coating and drying rolls, chute lining, linings for guide rails and any other non-stick low friction applications. It is an excellent release on mandrels.

SPECIFICATIONS

Toolcoat	#805	#807	#812	#816
Thickness:	.005"	.007"	.012"	.016"
Glass Thickness:	.003"	.005"	.010"	.014"
Adhesion (oz/inch width)*	35	45	50	40
Electric Strength (volts/total)	3000	5000	6500	4200

Width: 1", 2", and 37" - Standard
Roll Length: 18 and 36 Yards per Roll - Standard
Temperature: -100 to 500 degrees F (-73 to 260 degrees C)

* Other adhesives and sizes available on request

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DATA SHEET

HK10-90 TAPE

HK10-90 series tapes are constructed of extruded PTFE film with a silicone polymer adhesive system. The PTFE film has been etched which enables the adhesive to be bonded to the substrate. The HK10-90 series tapes will operate at extreme temperatures and conform to the most intricate complex shapes. This conformability is due to the high elongation of the film.

HK10-90 series tapes offer excellent release characteristics as well as chemical resistance. typical applications include: Wire and cable wrap, Lining of heat sealing surfaces on flexible packaging machinery, Covering aircraft tooling for a semipermanent release surface, and electrical insulation.

SPECIFICATIONS

Part Number	HK10-90-125	HK10-90-127	HK10-90-129	HK10-90-131
Backing Thickness (ins)	.002	.003	.005	.010
Total Thickness (ins)	.004	.006	.007	.012
Adhesion (ozs/in/width)	25	25	35	40
Breaking Strength (lbs/in/width)	10	10	20	40
Elongation (%)	100	300	300	300
Dielectric strength (volts total)	8400	10200	14000	15600
Operating Temp (F)	550	550	550	500
Roll Lengths (yds)	36	36	36	36
Color	Natural	Natural	Natural	Natural

Material will meet: Military Specifications: MIL-I-23594A and AA 59474

Widths Available 1/4" through 40"

Core: 3" ID

Packaging Available: shrink pack, boxed or bulk packed

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DATA SHEET

HK10-90127-27

HK10-901127-27 PRESSURE SENSITIVE TAPE is a TFE impregnated fiberglass coated with pressure sensitive adhesive. It's use is primarily as an electrical or insulation tape.

SPECIFICATIONS

Material:	Teflon coated Glass Fiber Fabric
Nominal Thickness:	0.006 inches
Width:	2 inches
Length:	108 feet
Dielectric:	500 volts per mil
Temperature	480° F

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DATA SHEET

HK2800 PS

HK2800 PS TAPE is a 4 mil. fiberglass coated with a silicone adhesive for holding and resin control. The high strength of the fiberglass makes this tape ideal for resin control and resin removal.

HK2800 PS was designed for use in pressures of 100 psi (7.08 Kg. per sq. cm.) and temperatures of 350 degrees F (176 degrees C). HK2800 PS removes clean after cure, and any residue can be removed with common shop solvents.

SPECIFICATIONS

Thickness:	.007"
Width:	1" and 2" - Standard
Roll Length:	60 Yards - Standard
Adhesion:	45 oz./inch width
Breaking Strength:	155 lbs/inch width
Color:	White
Temperature:	500 degrees F (260 degrees C)

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DATA SHEET

HK9710 PLASMA SPRAY MASKING TAPE

HK9710 Plasma Spray Masking Tape is a silastic impregnated glass cloth, silicone adhesive coated on one side, separated by a heavy duty release liner.

HK9710 is used as a high temperature masking tape in the metal plasma spray process in aircraft manufacturing, securing thermal insulation on aircraft heating or ventilation ducts; or as a harness wrapping around exhaust ducts, exhaust stacks of jet engines.

SPECIFICATIONS

Color:	White
Total Thickness, (mils)	11 (+/- 1)
Backing Thickness (mils)	8.0
Tensile Strength, lbs/inch	190
Elongation (%)	5 - 10
Adhesion to Panel, ozs/inch	30
Adhesion to Backing, ozs/inch	26
90° Tack, ozs/inch	24
Dielectric strength (volts, total)	7,000

FEATURES

Glass cloth backing
Semi-cured thick silastic back coating

Silicone adhesive

BENEFITS

Strong, tear resistant, high temperature, impregnable, printable
Protects tape and the masked area with it from very high temperature.
Adheres well to its own backing
Very high temperature, heat resistant, non-corrosive, radiation resistant, adheres to silicone surfaces.

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DATA SHEET

HK6615-07R TAPE

HK6615-07R is a pressure sensitive tape manufactured with a woven fiberglass substrate coated on both sides with silicone adhesive. HK6615-07R is exceptionally stable at high temperatures, allowing it to withstand temperatures to 500°F (260°C). HK6615-07R is a non-corrosive product and can be used in a variety of critical electrical applications.

SPECIFICATIONS

Substrate Type:	Woven fiberglass ("E" type)
Adhesive Type:	High temperature silicone
Overall Thickness (nominal):	.007" (.178mm)
Substrate Thickness (nominal):	.0048" (.122mm)
Adhesive Thickness (nominal):	..0011"/.0011" adhesive per side 28mm/28mm adhesive per side
Breaking Strength (nominal):	w=120/f=180 (pounds/1 inch of width) w=1051/f=1576 (newtons/5cm)
Operating Temperature:	-100°F – 500°F (-78°C – 260°C)
Dielectric Strength (nominal):	5000 volts
Peel Strength (nominal)	35 ounces/inch of width 19.2 Newtons/5cm
Elongation%:	<5.0 @ break
Adhesive Shelf Life	>6/<12 months

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DATA SHEET

HK8544PS Polyurethane Protective Tape

HK8544PS is manufactured with an exceptionally tough, abrasion resistant polyurethane, designed primarily for indoor industrial type applications. They are pre-coated with acrylic for long-term applications.

SPECIFICATIONS

Color:	Glossy Black	
Approximate Thickness	.006" (0.15mm)	
Overall Thickness	.009" (0.23mm)	
Tolerance	+/- .001" (0.025mm)	
Density: lbs/ft ² (kg/m ²)	68 (1090)	
Roll Width: Maximum	48" (1220mm)	
Liner:	paper	
Film Property:	Test Method	
Tensile	ASTM D882	50
Strength	Method A lbs/in (N/100mm)	50 (875)
Elongation @ Break (%)	ASTM D881 Method A	600
Tear Strength lbs (kg)	ASTM 1938	2.5 (1.1)
Dielectric Strength	ASTM D1000	9,500 volts
Adhesive Properties		
Adhesive Type		Acrylic
Adhesion	ASTM D1000	
24 hr dwell at room temp	180" peel at 12" per minute	oz/inch (N100mm)
Glass		52 (57)
Aluminum		67 (73)
Acrylic Enamel		48 (52)
ABS Plastic		55 (60)
Environmental Exposure		
Low Temperature Flexibility:	¼" mandrel bend – no cracking after 24 hours @	-60°F (-51°C)
Max Service Temp (Film softens above this temp)		300°F (149°C)

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DATA SHEET

HK1929 SPLICING TAPE

HK1929 Splicing Tape has a specially engineered pre-cured silicone pressure sensitive adhesive designed to be fully stable electrically and mechanically at operating temperatures up to 385°F (196°C). The film is clear; the adhesive is cured to provide maximum resistance to chemicals, and leaves no residue during masking or holding applications. Some of the recommended applications include splicing silicone release papers and films, outer wraps on coils, capacitors, motors, transformers, masking tape in electroplating, anodizing and p.c. boards.

SPECIFICATIONS

Color	Clear
Tape Thickness, mils	2.5
Backing Thickness, mils	1.0
Tensile Strength, lbs/inch	20
Elongation, %	100
Adhesion to Panel, ozs/inch	20
90° Tack, ozs/inch	10
Dielectric Strength, volts	5000
Insulation Resistance, megohms	1x1,000,000
Electrolytic Corrosion Factor	1.10
Insulation Class, centigrade	130
180° Holds, 1000 grms (PSTC-7 method)	14 days +
Lap joint, 600 grms-150°C	60 minutes+
Resistance to:	
Abrasion, acid, oil, solvent	Excellent
Aging, staining, water immersion	Excellent

FEATURES AND BENEFITS

Silicone adhesive	High temperature stability
Transparent	Visual inspection
Solvent resistant	No adhesive break-down
No adhesive residue	No clean up
High temperature	withstands 385°F (196°C)

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DATA SHEET

HK4105 TAPE

HK4105 Tape is a vinyl color coding tape used in the de-bulking process of composite work. HK4105 is an electrical grade polyvinyl chloride tape with a pressure sensitive rubber adhesive available in 13 colors. It is highly conformable and abrasion resistant. It is also easy to apply and has excellent adhesion for a fast and firm hold. HK4105 is resistant to moisture, alkalies, acids and corrosion.

SPECIFICATIONS

Color:	Yellow, Red Blue, Dark Blue, Green, Kelley Green, Black, White, Grey, Brown, Clear, Orange, Purple
Total Thickness:	.0005"
Adhesion:	24 oz/in
Tensile Strength:	14 lbs/inch
Elongation:	170%
Temperature Range:	32°F – 176°F (0° - 80°C)
Dielectric Strength:	6000 volts

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DATA SHEET

HK87-3208 SEAL-OFF TAPE

HK87-3208 Tape is formulated with butyl elastomers to achieve stretch, both width and length-wise resulting in a weather-proof seal with flexibility.

HK87-3208 features outstanding adhesion from 50 °F to 100°F (10°C – 38°C) even after the tape has been subjected to low or elevated temperatures. The ease of application of our 87-3208 tape is an additional benefit. HK87-3208 features a crinkle finish, silicone treated paper backing allowing easy release of the tape.

Hawkeye's rigid quality control program assures you of a consistent high quality tape where inferior raw materials are never substituted.

SPECIFICATION

Thickness:	1/8"
Standard Roll Size:	2" wide X 30 yds
Case Size:	8 rolls per case

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DATA SHEET

HK3480 ALUMINUM FOIL TAPE

Hk3480 Aluminum Foil Tape is manufactured with an acrylic adhesive for a “cleaner” release. HK3480 meets government specification L-T80B, MIL-T-233978, Amendment 2, Type II.

HK3480 is designed to stick firmly to its own backing, this dead soft aluminum foil has the ability to adhere to a wide variety of surfaces, offering vapor barrier protection, waterproof sealing, heat reflection/dissipation and reliable properties for masking in paint stripping and electroplating.

HK3480 can be applied at low temperature, and has good high and low temperature resistance. It is coated with an aggressive acrylic adhesive system which creates a superior bond to metal which is characteristic of a quality pressure sensitive product. Due to the dead-soft nature of the foil, HK3480 can be used on irregular and carved surfaces.

SPECIFICATIONS

PHYSICAL PROPERTIES	DATA	TEST METHOD
Substrate	Dead Soft Aluminum	
Adhesive	Acrylic	
Foil Thickness	3.0 mils	PSTC-33-ASTM D3652
Tape Thickness	5.0 mils	PSTC-33-ASTM D3652
Adhesion to Steel	65 oz/inch	PSTC-1 ASTM D3330
Tensile Strength	26 lbs/inch	PSTC-31 ASTM D3759
Elongation	5.5%	PSTC-31 ASTM D3759
Release Liner	none	
Government Specification	L-T 80B, MIL-T-23397B, Amendment 2, Type II	

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DATA SHEET

HK757 THERMAL SPRAY MASKING TAPE

HK757 Thermal Spray Masking Tape is a silastic impregnated glass cloth, silicone adhesive coated on opposite side, separated by a heavy-duty release liner. HK757 Tape is used in the plasma spray process.

This is a method of applying thin coatings of metal or high-temperature ceramics to a surface. The coating is sprayed at high pressure and at extreme temperatures. The tape is applied adjacent to areas of parts which are to be plasma sprayed. HK757 protects these areas both from the grit blasting, which is used as a surface preparation, and from the actual plasma spray coating

SPECIFICATIONS

COLOR:	WHITE
TOTAL THICKNESS:	12.0 +/- 0.5 MIL
BACKING THICKNESS	4.5 +/- 0.5 MIL
LINER	2.0 MIL POLYESTER EASY RELEASE
ELONGATION	10%
SILICONE ADHESION TO PANEL (PSTC-1 Test Method)	30 OZ
SILICONE ADHESION TO LINER (PSTC-4 Test Method)	2 OZ
TENSILE STRENGTH:	190 LBS/IN

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DATA SHEET

HK2381 TAPE

HK2381 Tape is manufactured from silicone rubber with a fiberglass cloth backing coated with high-temperature silicone adhesive. HK2381 is manufactured to withstand both the punishing abrasion of grit blasting and the extreme temperatures and pressures associated with the plasma spray process. The adhesive of HK2381 is a high temperature silicone which allows the product to withstand continuously temperatures up to 500°F. HK2381 also prevent tape slippage after application. HK2381 Tape has excellent strength and flexibility which allows for easy wrapping of complex shapes and minimizes wrinkling during the flexing of cables.

SPECIFICATIONS

Backing Material	Glass and Silicone
Adhesive Type	Silicone
Total Thickness (in)	.0120
Backing Thickness (in)	.0080
Adhesive Thickness (in)	.0040
Adhesion to Steel (oz/in)	50
Tensile Strength (lbs/in)	100
Dielectric Strength (volts)	7000
Operating Temperature (F)	-100° - +500°
Color	White

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DATA SHEET

HK9915-7 THERMAL SPRAY TAPE

HK9915-7 is a glass fabric tape coated with a silicone adhesive superior bonding. HK9915-7 is an excellent product used as a light duty plasma or flame spray masking tape. The wide range of applications includes general industry electrical maintenance to high-temperature splicing and wrapping. Some specific applications for HK9915-7 are over-wrap on motor rewinds, protective wrapping for wire and cables and high-temperature masking tape for welding stainless steel.

HK9915-7 is an excellent tape in applications that require continuous temperatures of up to 500°F. HK9915-7 is an exceptionally strong abrasion resistant tape and provides maximum solvent resistance. It also has excellent temperature resistance and is thermally stable.

HK9915-07 meets MIL-I-19166C.

SPECIFICATIONS

Total Thickness:	.007"
Adhesive:	Silicone
Backing Thickness (in/mm)	.0045
Adhesive Thickness (in)	.0025
Adhesion to Steel oz/in, gr/cm	40
Break Strength (lbs/in)	160
Elongation (% at break)	N/A
Dielectric Strength (volts)	4000
Operating Temperature	-100°F to 500°F/ -73°C to 260°C
Color:	White

Values shown are typical. Certified test reports for writing specifications are available.

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DATA SHEET

HK9915-10 THERMAL SPRAY TAPE

HK9915-10 is a glass fabric tape coated with a silicone adhesive for superior bonding. HK9915-10 is an excellent product used as a light duty plasma or flame spray masking tape. The wide range of applications includes general industry electrical maintenance to high-temperature splicing and wrapping. Some specific applications for HK9915-10 are over-wrap on motor rewinds, protective wrapping for wire and cables and high-temperature masking tape for welding stainless steel.

HK9915-10 meets MIL-I-19166C. HK9915-10 is an excellent tape in applications that require continuous temperatures of up to 500°F. HK9915-10 is an exceptionally strong abrasion resistant tape and provides maximum solvent resistance. It also has excellent temperature resistance and is thermally stable.

HK9915-10 meets MIL-I-19166C.

SPECIFICATIONS

Total Thickness:	.010"
Adhesive:	Silicone
Backing Thickness (in/mm)	.0055
Adhesive Thickness (in)	.0022
Adhesion to Steel oz/in, gr/cm	40
Break Strength (lbs/in)	175
Elongation (% at break)	N/A
Dielectric Strength (volts)	5000
Operating Temperature	-100°F to 500°F/ -73°C to 260°C
Color:	White

Values shown are typical. Certified test reports for writing specifications are available.

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DATA SHEET

HK33 Vinyl Electrical Tape

HK33 Vinyl Electrical Tape is a conformable 7-mil tape designed to perform in temperature environment to 176°F (80°C). It has excellent resistance to acid, alkalis, abrasion, moisture, corrosion and varying weather conditions (i.e. sunlight).

HK33 is used for primary electrical insulation for all wire and cable splices up to 600 volts and 176°F (80°C). It is used for wire and cable harnessing.

SPECIFICATIONS

Temperature Rating	176°F (80°C)
Color:	Black
Thickness (ASTM D1000)	.007"
Adhesion to Steel (ASTM D1000)	
72°F (22°C)	28 oz/in
0°F (-18°C)	60 oz/in
Adhesion to Backing (ASTM D1000)	
72°F (22°C)	25 oz/in
0°F (-18°C)	60 oz/in
Breaking Strength (ASTM D1000)	15 lbs/in
Ultimate Elongation (ASTM D1000)	
72°F (22°C)	250%
0°F (-18°C)	100%
Flammability (Max)	
UL510	1 sec
ASTM D1000)	4 sec
Voltage Rating (UL510)	600 volts

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DATA SHEET

HK35 ELECTRICAL TAPE

HK35 Electrical Tape is a colored, electrical grade, pressure sensitive, vinyl tape. HK35 Electrical Tape offers excellent adhesion to aluminum and copper conductors, plastic and rubber insulations and jackets where quick identification is most commonly needed. HK35 is thin, tough and resilient. It can be stretched to conform easily without breaking. It is easily applied at low temperatures.

SPECIFICATIONS

Color	Black - Also available in red, white, blue, yellow, orange, green, brown and grey	
Thickness	.007" (0.178 mm)	ASTM D1000
Tensile Strength	18 lbs/in	ASTM D1000
Elongation:	200%	ASTM D1000
Adhesion to Steel	20 oz/in	ASTM D1000
Adhesion to Backing	20 oz/in	ASTM D1000
Adhesion to Backing @ 7°C	50 oz/in	ASTM D1000
Unwind @ 7°C	100 oz/in	ASTM D1000
Flammability	4 max./second	ASTM D1000
Flagging	0 10 max/in	ASTM D1000
Temperature Rating		
Maximum	90°C	UL-510
	105°C	CSA-22-2
Minimum	10°C	UL-510
	0°C	CSA-22-2
Dielectric Strength		
Standard	7,000 volts	ASTM D1000
Wet	6,300 volts	ASTM D1000
Dielectric Constant	3.2	ASTM D 150
Power Factor	0.01	ASTM D 150
Insulation Resistance	1 x 10 megohms	ASTM D1000

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